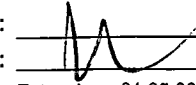
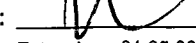


Date: Thursday, 9/11/2008 10:15:47 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ROUND BILLET 17-4
Job Number :	41967		
Estimate Number :	10041		
P.O. Number :		Part Number :	D6104007
This Issue :	9/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6104 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	39627	Drawing Revision :	B
		Material :	
Written By :		Due Date :	9/26/2008
Checked & Approved By :		Qty:	30
Comment :	Est. A: 01.05.08 New Issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 7144

a) Description: S.S round billet

b) Ø4.50" x 5.10" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)

e) One blank makes 2 parts

f) Material certification required

C 208/09/11

(30)

2.0

D6104007P

17-4 SS Roundbar 4.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
 17-4 SS Roundbar 4.50"OD

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 8/9/22

(30)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

SA 08/10/01 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/11/2008 10:15:47 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET 17-4

Job Number: 41967

Part Number: D6104007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/10/01 *[Signature]*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-01

Product Certification Report



VALBRUNA

SLATER STAINLESS, INC.

2400 Taylor Street West, P.O. Box 630

Fort Wayne, Indiana USA 46801

Phone: 260-434-2892 Fax: 260-434-2905

Report Number: 4381180

Certified on Jul 14, 2008 Page 1 of 2

Order I.D. 0801100 001		Order Date 4/16/08		Commodity Code 14998	
Dim 1 4.5000	Dim 2 .0000	Dim 3 .0000	Heat I.D. 246785	Customer I.D. 001123	Customer Purchase Order 01-49011
Product Shape Rounds			Product Surface HR & Rough Turned		Customer Grade 17-4
Length (inches) 132.000 Min. 156.000 Max.			Bill of Lading # 408142	Weight	

Ship
To

CASTLE METALS
3400 NORTH WOLF ROAD
FRANKLIN PARK, IL 60131

Sold
To

VALBRUNA STAINLESS, INC.
2400 TAYLOR STREET WEST
FORT WAYNE, IN 46802

Lifts: 0031 0032

AISI 630

UNS S17400

AMS 2303E

CONDITION A

ASTMA 564-04

AMS 5643R

3174-02 REV 23 DTD 11/15/01

ASMESA 564 01 ED 2002 ADD

CHEMICAL ANALYSIS

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.035	.54	.023	.021	.41	15.65	4.88	.22	3.32	.04	.22	.001	.221

HB

363

TENSILE PROPERTIES
CAPABILITY

HB	TS (PSI)	.2%YS (PSI)	%EL(4d)	%RA	AGE(F)
411	192400	173200	17.5	51.9	900

MAGNETIC PARTICLE TEST

FREQ SEV

AVG .00 .00

PRODUCTION HEAT TREATMENT

SOL-ANN(F)	SOL-ANN(HR)	QUENCH
1900	9.75	Air

MACRO ASTM E340/E381

MACRO

OK

OK

OK

PERCENT FERRITE

% FERRITE

AVG .5

Reduction ratio 5 To 1 Min.

Electric Furnace melted; AOD refined.

Ultrasonic test OK.

Chemical testing performed to one or several of the following ASTM methods: E415, E572, E1019, E1085, E1086.

No mercury or low melting alloy contamination. No weld repair.

Material melted in Italy, manufactured in the United States.

Material conforms to listed specifications.

CASTLE METALS CORP.

DATE RCVD 7/16/08

IAC 14998

APPROVED BY [Signature]

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

Dennis Hackett

08 10:27 FROM-

T-490 P013/057 P-500
Product Certification Report



VALBRUNA
SLATER STAINLESS, INC.
2400 Taylor Street West, P.O. Box 630
Fort Wayne, Indiana USA 46801
Phone: 260-434-2892 Fax: 260-434-2905

Report Number: **4381180**

Certified on Jul 14, 2008 Page 2 of 2

Order I.D. 0301100 001		Order Date 4/16/08		Commodity Code 14998	
Dim 1 4.5000	Dim 2 .0000	Dim 3 .0000	Heat I.D. 246785	Customer I.D. 001123	Customer Purchase Order 01-49011
Product Shape Rounds			Product Surface HR & Rough Turned		
Length (Inches) 132.000 Min. 156.000 Max.			Bill of Lading # 408142	Weight	
			Customer Grade 17-4		

Ship To
CASTLE METALS
3400 NORTH WOLF ROAD
FRANKLIN PARK, IL 60131

Sold To
VALBRUNA STAINLESS, INC.
2400 TAYLOR STREET WEST
FORT WAYNE, IN 46802

Quality system is compliant with ISO 9001:2000. Produced in accordance with EN 10204 3.1B.

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

Dennis Hackett
Dennis Hackett

NO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO. 7144		COMPTE-ACCT. 91037	VEND.-SLS 200	TERR. 50	EXPEDIE PAR SHIP VIA MANITOULIN	F.A.B.-F.O.B. PREPAID		BILL	NO. REVILLE/EMBALLAGE/PA. NUMBER
ACHETEUR-PURCHASING AGENT LINDA LACELLE		TELEPHONE 613 632-3336	H/C 9	TAXE 0	NO. COM ORD 1	REGION LIVRAISON-DEL ZONE C/C.		INFORMATION CREDIT-CREDIT INFORMATION		ROUTE	
VIVRE A-SHIP TO:		VENDU A-SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		ROUTE 01-NL-09/ 30-NL-09/ 31-NL-09/	

INSTRUCTIONS/LIVRAISON-DELIVERY ING-183568		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)	
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DESCRIPTION - ITEM 1 4.5000 RD 17CR-4NI RT SOL. TREATED COND A STNLS 5.10" GOLD		QTE/UNITE COM.-ORDERED 30 PCS		PCES/PO COM-ORD PCS		POIDS COM.-WT. ORDERED 716	
CERTIFICATE OF CONFORMANCE A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc. WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.		BALLOTS-BUNDLES 1		PCES/PO EXP. SHP. 30		POIDS EXP.-WT. SHIPPED 709	
		FORME-SHAPE 55.640FT		I.A.C. 14998			
INSTRUCTIONS TOL + 1/8" - 0 PRIOR DIST/ORD: 01 658765		COULÉE INFO-HEAT INFO QTE-QTY A15686 G10117 246785-0031 AL		INSTRUCTIONS (CONT'D.) 30 x 5.10		ENT.-WT 4	

DESCRIPTION - ITEM 2		QTE/UNITE COM.-ORDERED		PCES/PO COM-ORD		POIDS COM.-WT. ORDERED	
TERMS AND CONDITIONS OF SALE SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		BALLOTS-BUNDLES		PCES/PO EXP. SHP.		POIDS EXP.-WT. SHIPPED	
		FORME-SHAPE		I.A.C.			
INSTRUCTIONS 1 Box		COULÉE INFO-HEAT INFO QTE-QTY		INSTRUCTIONS (CONT'D.)		ENT.-WT	

DESCRIPTION - ITEM 3		QTE/UNITE COM.-ORDERED		PCES/PO COM-ORD		POIDS COM.-WT. ORDERED	
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.		BALLOTS-BUNDLES		PCES/PO EXP. SHP.		POIDS EXP.-WT. SHIPPED	
		FORME-SHAPE		I.A.C.			
INSTRUCTIONS 1 Spec/n		COULÉE INFO-HEAT INFO QTE-QTY		INSTRUCTIONS (CONT'D.)		ENT.-WT	

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)
RECU PAR-RECEIVED BY
DATE RECU-DATE RECEIVED